

Work Order ID 150585

Monday, August 29, 2016 2:42:51 PM

150585

Page 1

Item ID: D412-698-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller RH Aluminum Door

Start Date: 8/19/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 2.00

2

Customer:

Reference:

DAS

21

9-89

Approvals: Process Plan: Date: AUG 31 2016

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-012 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

X2 DAS
27
9-89

NOV 24 2016

2 DAS
6
9-89
DAS
28
9-89
OCT 06 2016X2 DAS
27
9-89

NOV 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐							
Misidentified ☐	☐	Past Due ☐	OTHER :						

Monday, August 29, 2016 2:42:51 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

130

Packaging

0.00

0.00

Packaging

Packaging

Identify and pack for shipping as per PPP D412-698-012
Location : FG034

2

DAS 27 9-89

NOV 24 2016

140

QC21- Final Inspection - Work Order Release

0.00

0.03

QC

Quality Control

Memo

DAS
21
9-89

NOV 24 2016

NOV 24 2016

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																									

Picklist Print

Monday, August 29, 2016 2:42:50 PM

Page 1

Work Order ID: 150585

150585

Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller RH Aluminum Door

Start Date: 8/19/2016

Required Date: 8/29/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-141		Manufactured	No			110	Each	11.0000	3	6			
D3121-141									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST018		11							
				146854		3							
				147922		8							

D3121-144		Manufactured	No			110	Each	3.0000	1	2			
D3121-144									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST018		3							
				143682		3							

D3137-043		Manufactured	No			110	Each	9.0000	1	2			
D3137-043									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST019		9							
				144597		1							
				148252		8							

D3183-044		Manufactured	No			110	Each	3.0000	1	2			
D3183-044									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST021		3							
				145457		3							

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST021		3							
				145457		3							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Monday, August 29, 2016 2:42:51 PM

Page 2

Work Order ID: 150585

150585

Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller RH Aluminum Door

Start Date: 8/19/2016

Required Date: 8/29/2016

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

24.0000

9

18

D3199-1

Bracket

**

150605

DAS
6
9-89

OCT 06 2016

DAS
28
9-8

DAS
27
9-89

Location

Loc Qty

Loc Code

ST022

24

147312

24

D3202-1

Manufactured No

110

Each

20.0000

1

2

D3202-1

Cover

**

DAS
6
9-89

OCT 06 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST195a

20

143726

5

147812

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																									

Work Order ID 150585

Thursday, October 13, 2016 7:45:43 AM

150585

Page 1

Item ID: D412-698-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller RH Aluminum Door

Start Date: 8/19/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-698	F

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

DAS
21
9-89

OCT 13 2016

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.01

Quality Control

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW